

Appl. No. 10/679,968  
Amdt. dated August 2, 2004  
Reply to Office Action of May 20, 2004

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1. (currently amended) A method of providing stress relief in an elongated longitudinally curved panel having a central portion and at least one upstanding longitudinally extending side flange comprising the steps of:

providing an elongated panel having a central portion and a longitudinally extending zone of material,

forming closed apertures fully within in said longitudinally extending zone of said panel, bending said zone relative to said central portion so that said apertures remain closed, and

bending curving the panel longitudinally.

2. (currently amended) The method of claim 1 wherein said zone is bent relative to said central portion prior to the panel being ~~bent~~ curved longitudinally.

3. (original) The method of claim 1 wherein said apertures are formed by punching the apertures in the panel.

4. (canceled)

5. (currently amended) The method of claim 4 further including the step of forming some open apertures in said zone prior to bending said zone relative to said central portion wherein at least some of the apertures are open.

6. (currently amended) The method of claim 1 wherein said closed apertures have a shape selected from the group consisting of V-shaped, Y-shaped, X-shaped, U-shaped, W-shaped, M-shaped, triangular-shaped, diamond-shaped and half-moon crescent shaped.

7. (original) The method of claim 1 wherein said zone is bent to be perpendicular to said central zone.

8. (original) The method of claim 7 wherein there are two zones, one on either side of said central zone.

9. (original) The method of claim 1 wherein said central portion intersects with said zone along a line of intersection and said line of intersection is curved in a longitudinally extending direction.

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10. (original) The method of claim 1 wherein said panel is bent with rollers.
11. (new) The method of claim 1 wherein said apertures in said zone form a plurality of parallel, laterally-extending columns, spaced apart along the longitudinal length of the zone.
12. (new) The method of claim 1 wherein said zone is bent relative to said central portion into a single layer.